

Work Order ID 52685

October 7, 2009 10:24:10 AM



Page 1

Item ID:	D2512	Accept		Setup	Start	
Revision ID:	E				Stop	
Item Name:	Basket Lid 205/350					
Start Date:	07/10/2009	Start Qty:	1.00			
Required Date:	15/10/2009	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	09-10-7	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2512	Rev E

100	Weld per dwg A/R S.S. rod Batch: <u>H109213</u>	0.00							
	Large Fab								
Large Fab									
Large Fab	Memo 1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 2-Cut (4) D2236 From D3166-3 3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305 4-Weld as per Dwg D2512 using Welding Jig Debur as required ***INSTALL D2012-II 7 CLEVIS ONLY ON D130-701-041***	0.00							
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
Quality Control	Memo	0.00							

PD 09.10.15

Cpl 09 10 19

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Item ID: D2512	Accept		Setup	Start	
Revision ID: E				Stop	
Item Name: Basket Lid 205/350					

Start Date: 07/10/2009	Start Qty: 1.00		Cust Item ID:	
Required Date: 15/10/2009	Req'd Qty: 1.00		Customer:	

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	HandFinishing	0.00							
	HandFinish								
Hand Finishing	Memo <i>m 111 301 BLACK PAINT</i> Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: <i>M 112/06</i>	0.00				<i>BR 09-10-21</i>	<i>①</i>		
150	QC3- Inspect Part Finish	0.00							
	QC								
Quality Control	Memo	0.00				<i>MD 09/10/21</i>	<i>X1</i>		
160	Identify as per dwg & Stock Location:	0.00							
	Packaging								
Packaging	Memo	0.00							

PP 52680

9/10/22 SP

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Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 07/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 15/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/22 *[Signature]*
09-10-22

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Work Order ID: 52685

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350


Start Date: 07/10/2009

Required Date: 15/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117RevC		Manufactured	No			100	Each	30.0000	2.0000			
												
Clevis												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	30	
31101	2	
52498	28	

DD 09.10.13

ONLY APPLICABLE ON D130-701-147

D2232-1RevC

Manufactured No

100

Each

30.0000

2.0000

Basket Hinge

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
48230	2	
Main Warehouse		
WA	28	
50896	8	
51105	20	

DD 09.10.13 ②

Picklist Print

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Work Order ID: 52685



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 07/10/2009

Required Date: 15/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-1RevD		Manufactured	No			100	Each	20.0000	2.0000			



Spacer Bushing

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

20

51331

20

100

Each

6.0000

1.0000

PD 09.10.3 ②

D2506RevF

Manufactured

No



Label Plate

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

2

44275

1

51135

1

Main Warehouse

WA

4

51303

4

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Work Order ID: 52685



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 07/10/2009

Required Date: 15/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	76.0000	2.0000			

Mounting Bracket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	13	
46086	2	
48428	1	
51120	10	
Main Warehouse		
WA	63	
50872	14	
51745	49	

PD 09.10.08

D3166-3RevA1

Manufactured No

100

Each

13.6210

1.0000



Basket Hoop

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	13.621	
50033	0.0527	
50618	1.5683	
51249	6	
52058	6	

PD 09.10.08 (1)

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Work Order ID: 52685



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 07/10/2009

Required Date: 15/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	306.0011	18.9474			
Expanded Metal Flat SS												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	306.0011065	
110134	6.7	
110629	14.41	
111630	9.15	
111956	0.000017	
112147	54.8205895	
112311	28.9205	
112707	192	

PD 09.10.13

M304TS0.750W.065

Purchased

No

100

f

678.9022

45.8741



304 SQ Tube .75x.75x.065W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	678.9022	
112398	678.9022	

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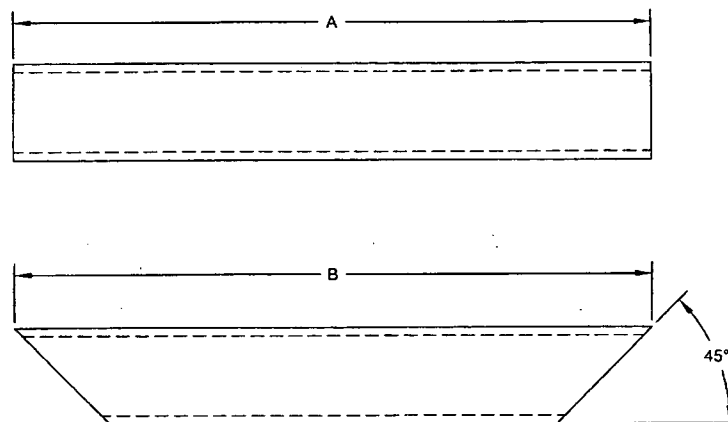
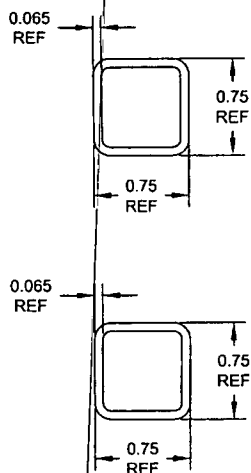
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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

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NO. 52485
09-10-7



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08-08-21-117

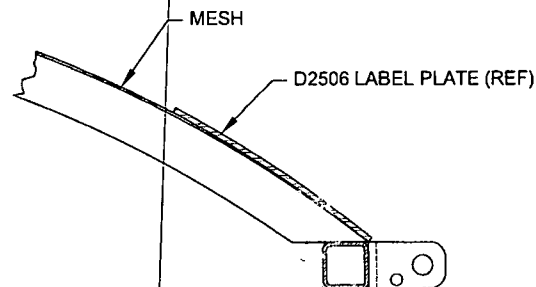
D2512-1/-3/-5/-7 NOTES:

- MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- FINISH: N/A
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: N/A
- CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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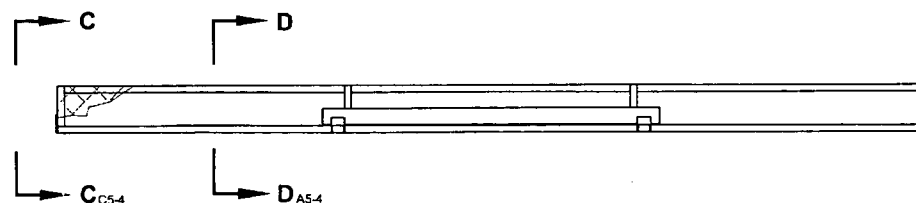
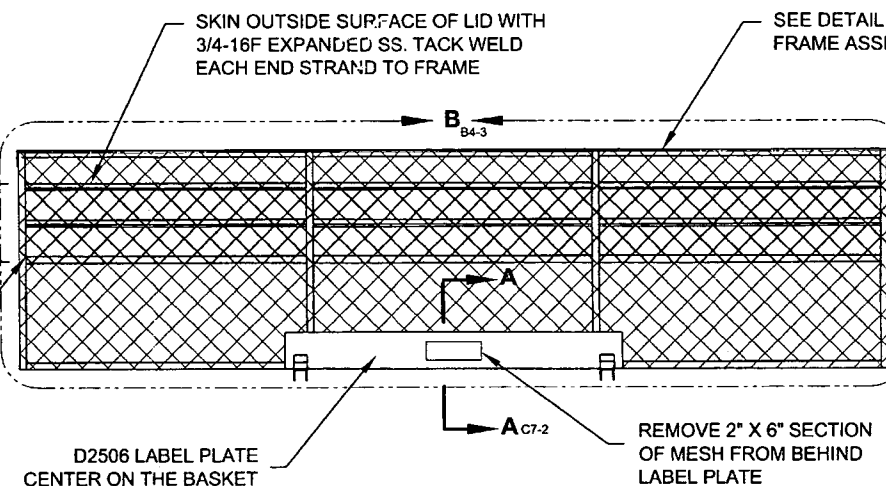
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NO. 52685
BL 09-10-7



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



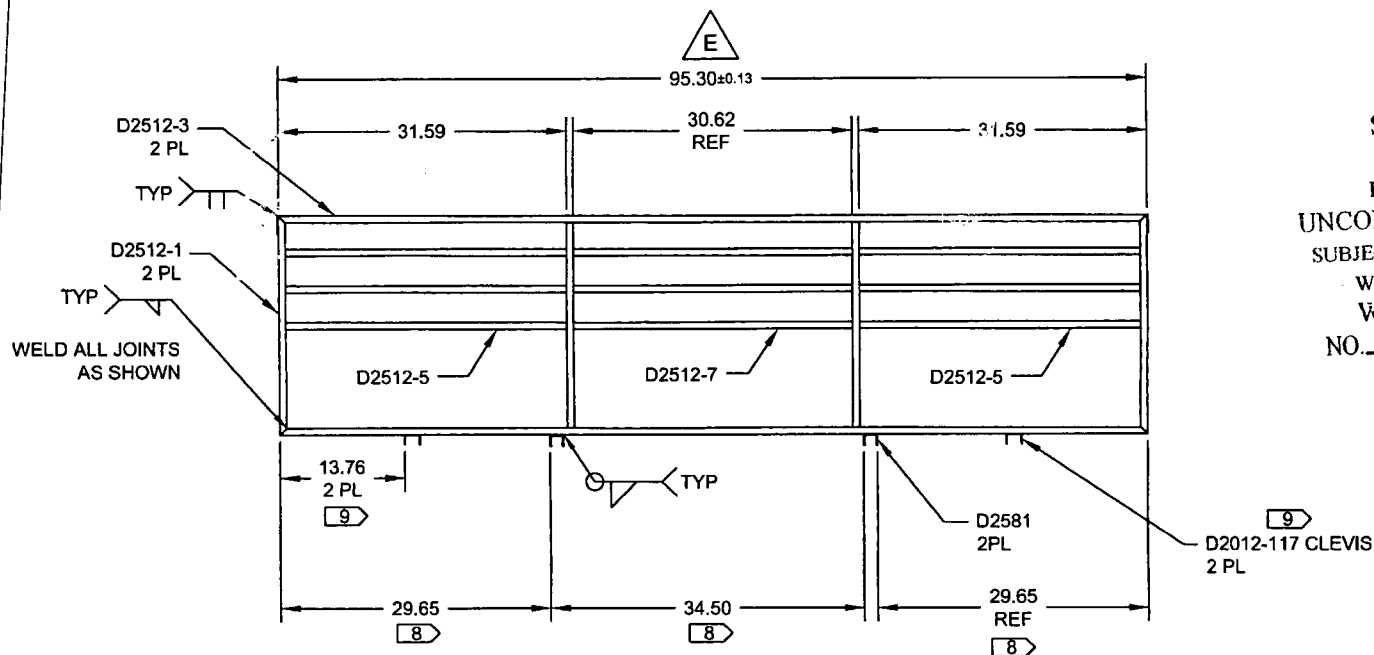
E

D2512 BASKET LID ASSEMBLY NOTES:

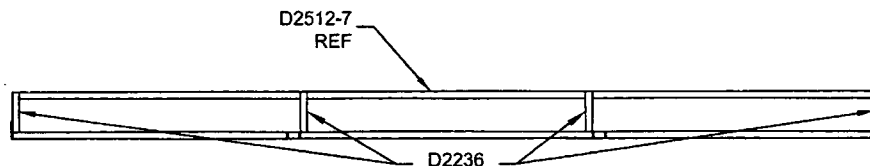
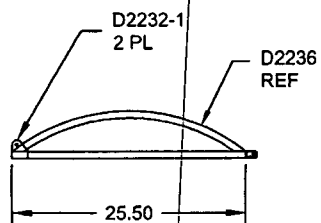
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 3) SPRAY PAINT BLACK INSIDE SURFACE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

RELEASED
08 08 21/17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



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NO. 52455
BH 09-10-7

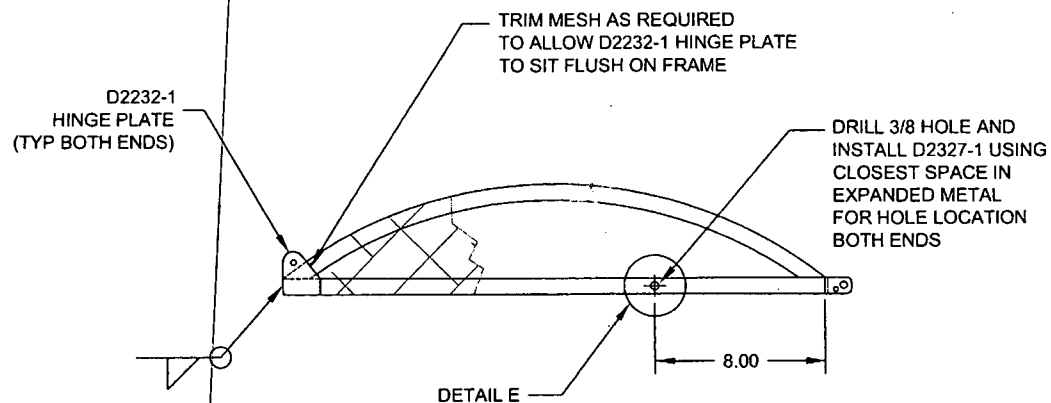
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08-06-17

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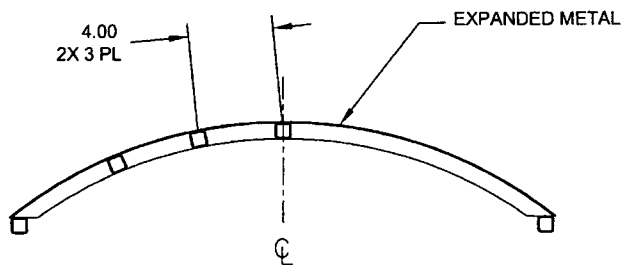
MATERIAL: NONE
FINISH: NONE
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: N/A
IDENTIFICATION: NONE
WEIGHT: N/A
LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2512	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1

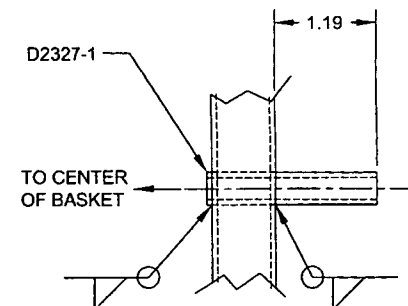


VIEW C-C SIMILAR BOTH END RIBS A5-2







SECTION D-D SAME BOTH CENTER RIBS A4-2

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DETAIL E C6-4

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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